

Date: Tuesday, 04/11/2008 8:34:09 AM  
 User: Linda Lacelle

# ss Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 43179  
 Estimate Number : 13589  
 P.O. Number :  
 This Issue : 04/11/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : R&D THERMOFORMING  
 Previous Run : 42071

Drawing Name : REAR OVERHEAD L/H

Part Number : D38231  
 Drawing Number : D38231 UNDER REVIEW 08-11-06  
 Project Number : IN0002  
 Drawing Revision : A UNDER REVIEW  
 Material : MKYDEX6185S80P362015  
 Due Date : 14/11/2008 Qty: 2 Um: Each

Written By :  
 Checked & Approved By :  
 Comment : Est. A New Issue 08/09/17 DL

## PROTOTYPE

PLEASE RETURN ALL ISSUED  
 DATA TO ENGINEERING

04/11/2008 Dh

POSITIVE  
 RECALL

### Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MKYDEX6185S80P362015 Kydex velour matte, ivory



Comment: Qty.: 11.3747 sf(s)/Unit Total : 22.7493 sf(s)  
 Kydex velour matte, ivory

M109703

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

08/11/04 Dh

3.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

08/11/04 Dh

4.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3823-1and folio (FTA 9112 Prototype ) using tool DT 9112

Dwg. Rev. A UNDER REVIEW.  
 Folio Rev. A

08/11/04 Dh

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

08/11/04 Dh

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 04/11/2008 8:34:09 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD L/H

Job Number: 43179

Part Number: D38231

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*208-11-26 (2)*

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

*BB 08/11/27 (X2)*

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING  
APPROVAL**

*PH 08-12-01*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*NA*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08.12.01 Presotype*

Job Completion



*W 08.12.24*

**POSITIVE RECALL**

EFFECTIVE *08.11.04* AUTH *G*

RELEASED

DATE

*Annual*

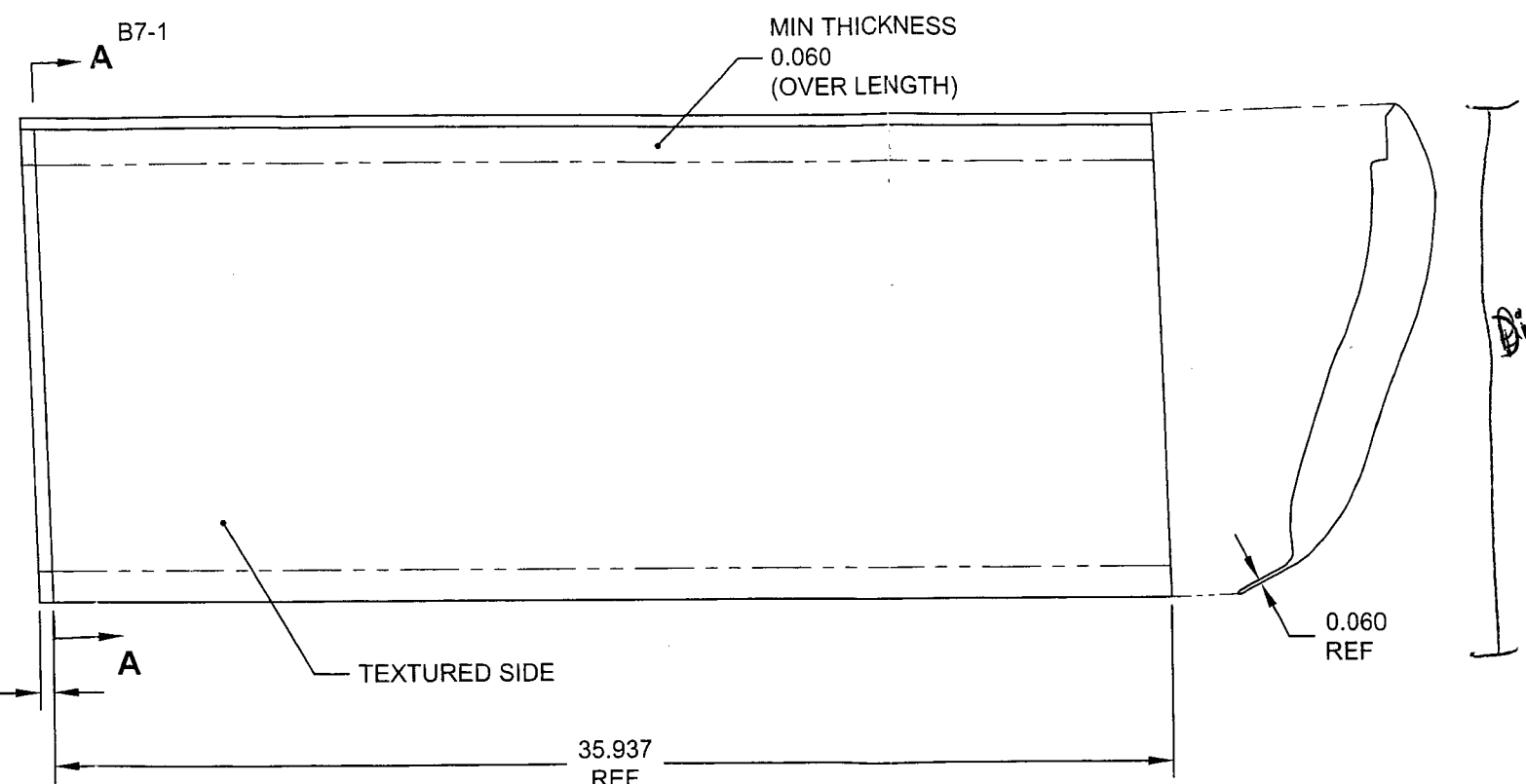
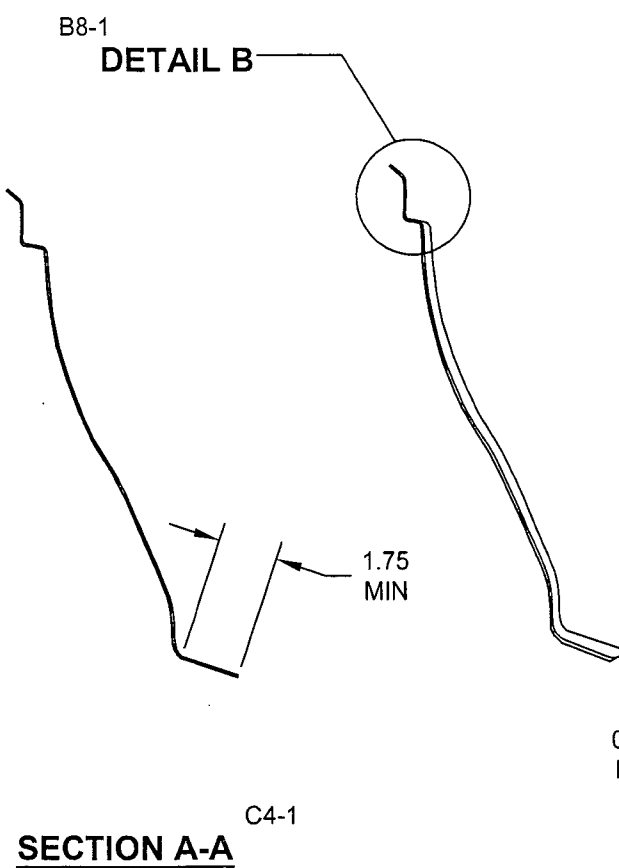
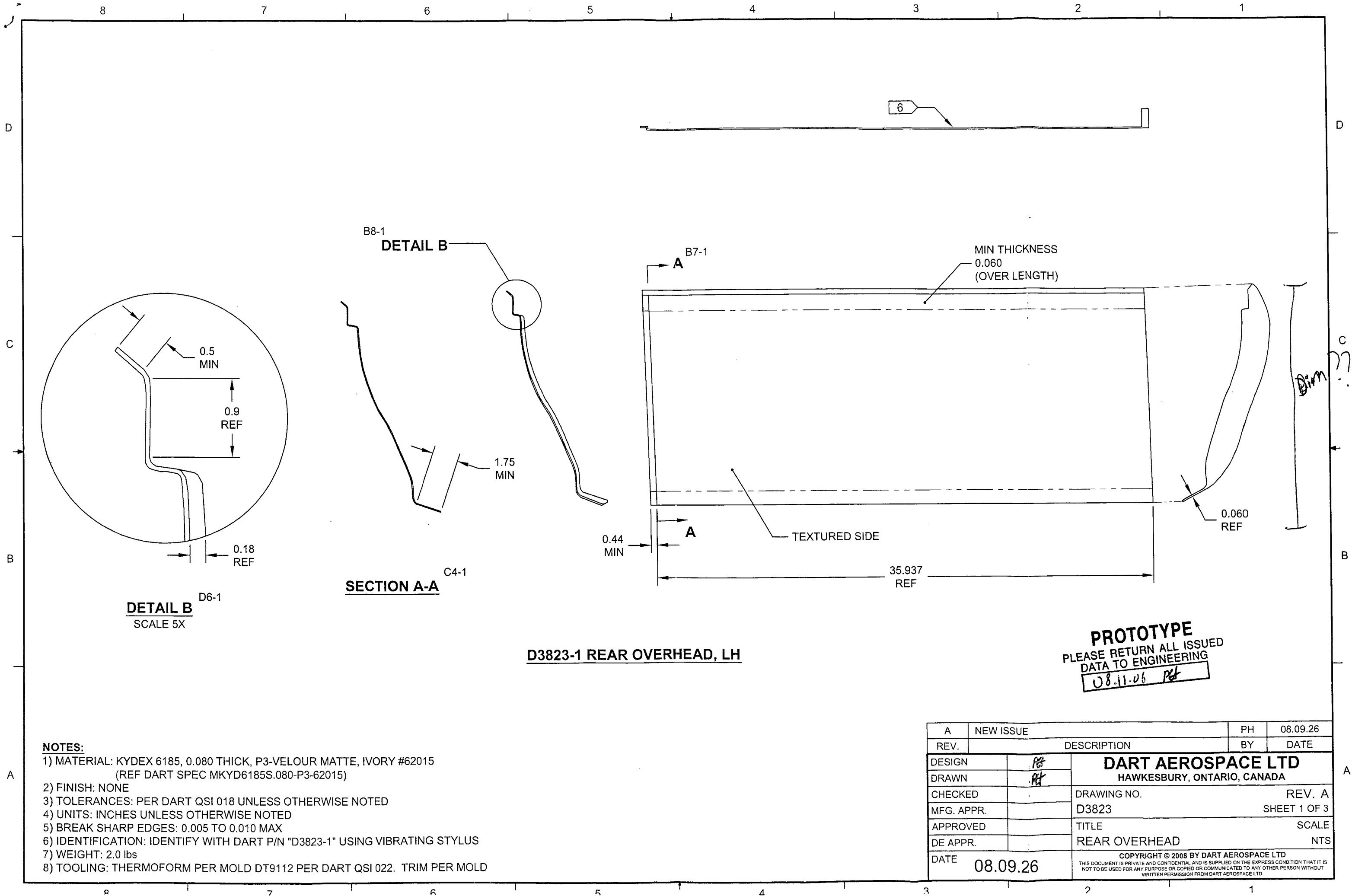
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3823-1 REAR OVERHEAD, LH**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
08.11.06 *PH*

- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015  
(REF DART SPEC MKYD6185S.080-P3-62015)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3823-1" USING VIBRATING STYLUS
  - 7) WEIGHT: 2.0 lbs
  - 8) TOOLING: THERMOFORM PER MOLD DT9112 PER DART QSI 022. TRIM PER MOLD

A	NEW ISSUE	PH	08.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3823	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		REAR OVERHEAD	NTS
DATE	08.09.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

## Receiving Report

**Date:**

**Batch No:**

**Supplier:**

Dart P/O:

**Packing Slip:**

**Yes**

**No**

Invoice:

**Yes**

No

**Receipt:**

**Cash**

Cr

Release Note Attached:

Yes

~~No~~

N/A

Waybill Attached:

Yes

No

## Shipment Complete

Yes

No

N/A

### QC6 Inspection

## Work Order

N/A

N/A

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

**Admin:**

### Location

سابك  
SABIC

**SABIC Polymershapes**

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3  
TEL: 613 745 7043 FAX: 613 745 8163

## CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # : 1

QUANTITY: 51

59 8 Oct 07

08/10/27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL  
BRANCH MANAGER

DART AEROSPACE LTD		Work Order: 43179
Description: Rear overhead LH / B Prototype		Part Number: D3B23-1
Inspection Dwg: D3B23 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			None.

Measured by: <i>D. Heger</i>	Date: 08.11.07
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### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.937 (ref)	$\pm \frac{1}{16}$ (Ref)	35.93	✓			I don't believe this should be a Ref dimension.
0.44	$\pm 0.035$	0.44	✓			
0.9 (Ref)		0.92	✓			
0.5	$\pm 0.100$	0.5	✓			
1.75	$\pm 0.030$	1.75	✓			
Min 0.060" thickness	Min.	0.070	✓			
0.18 (Ref.)		0.185	✓			

Measured by: <i>DH</i>	Date: 08/11/07
Audited by: <i>[Signature]</i>	Date: 08.11.26
Prototype Approval: <i>[Signature]</i>	Date: 08.12.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	